

Date: Wednesday, 1/11/2006 4:29:34 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE BRACKET (206I)
Job Number : 25473	
Estimate Number : 11007	
P.O. Number : N/A	Part Number : D2607
This Issue : 1/11/2006 S.O. No. : N/A	Drawing Number : D2607 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : 25143	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 1/30/2006 Qty: 10 Um: Each
Checked & Approved By : SEE ABOVE DATE & USER	
Comment : Est. E 02.06.05 Added alodine finish TSR 1290 NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1313 sf(s)/Unit Total : 1.3125 sf(s)
 2024-T3 .040 sheet
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 Stack of 10
 (M2024T3S.040) Batch 1119059

2.0	SHEAR	SHEAR
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ml 06/02/20 10
ml 06/02/20 10

Comment: SHEAR

Cut Blank per template DT0247

Cut Blank 1.891 x 9.030 (66 in Along 9.030" OFF SET)
100°

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2607

ml 06/02/20 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/02/20 10

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

J.L 06/02/20 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SD Date: 06/02/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: ~ Wednesday, 1/11/2006 4:29:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE BRACKET (2061)

Job Number: 25473

Part Number: D2607

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr *SAP 06:02:22 10*

Form as per Dwg D2607

SB 06/02/24

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-02-24

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Sad 06:02:26 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *use them w/ 25473*

ml 06/02/27

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/02/27

Job Completion



U 06.02.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

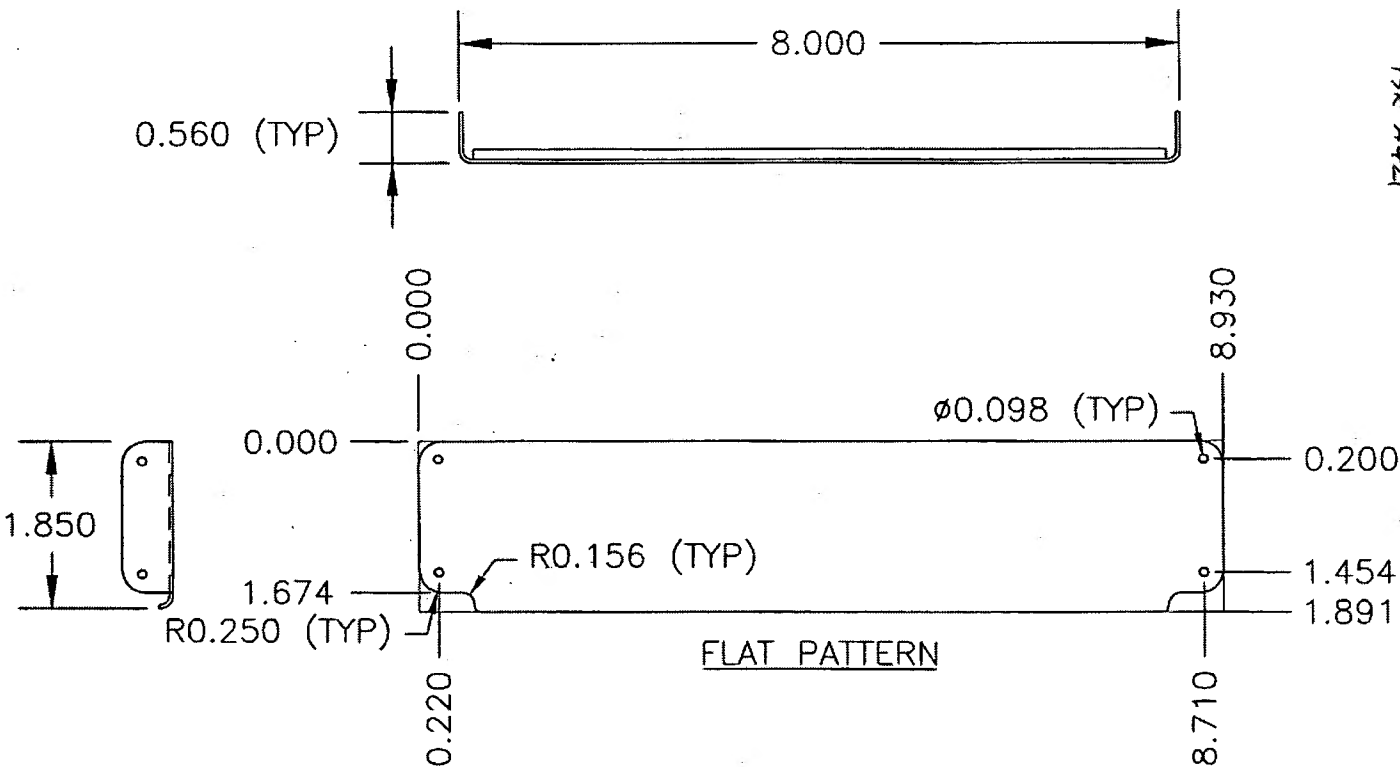
NOTE: Date & initial all entries

DART



RELEASED
97.11.04 KE
TSR 4421

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
<i>[Signature]</i>	<i>BW</i>	DRAWING NO.	REV. A
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	D2607	SHEET 1 OF 1
DATE 97.10.23	TITLE CONSOLE BRACKET	SCALE 1:2	
A	97.10.23	D2607 WAS D206-547-9	
AI	02.06.04	ADD FINISH	



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2607
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



OBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 25473

